

Date: Monday, 11/05/2009 1:20:59 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CLIP
Job Number	: 47846		Part Number	: D30821
Estimate Number	: 11556		Drawing Number	: D3082 REV A
P.O. Number	:		Project Number	: N/A
This Issue	: 11/05/2009 S.O. No. :		Drawing Revision	: A
Prsht Rev.	: NC		Material	:
First Issue	: / / Type : PURCHASED PARTS		Due Date	: 22/05/2009
Previous Run	: 47294		Qty:	12
Written By	:		Um:	Each
Checked & Approved By	<u>1009.05.11</u>			
Comment	: Est: B 02.05.11 Added step 3 NG			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: PURCHASING Issue P/O: <u>8787</u>	<u>CH09105/12</u> 
	Description: Crawford peg hooks #18612. <u>17224Y3</u> mcmaster	
	Possible supplier: Canadian tire	
2.0	-18612- 1722 4Y3	Clip
	Comment: Qty.: 1.0000 Each(s)/Unit	Total : 6.0000 Each(s)
	CLIP	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached	
4.0	QC6	DIMENSIONAL CHECK
	POSITIVE RECALL	
	EFFECTIVE <u>09.05.12</u> AUTH <u>UL</u>	
	Comment: DIMENSIONAL CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Cut clip and drill as per dwg D3082 Deburr.	

W/O: 47846		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.05.22	S.1	FLATTE N BOTTOM OF CLIP, DISCARD INCLUDED  SCREWS	FF 09/05/22			GP 09.05.22 OSI 042	S 09/05/22

Part No: D3082-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/09/09 counter X20

7.0 POWDER COATING

POWDER COATING



m 111472

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2 Steel) as per QSI 005 4.3

START TIME: 10:00

OVEN TEMPERATURE: 400°

FINISH TIME: 10:30

20

FL 09/06/01

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5/09/06/02 counter X20

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST63

Pa g6/2 (20)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/02 JH

Job Completion



MF
09-06-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	D3082	REV. A SHEET 1 OF 1
DATE		TITLE	CLIP	SCALE NTS
02.01.21		A	02.01.21	NEW ISSUE

SPECIFICATION CONTROL DRAWING

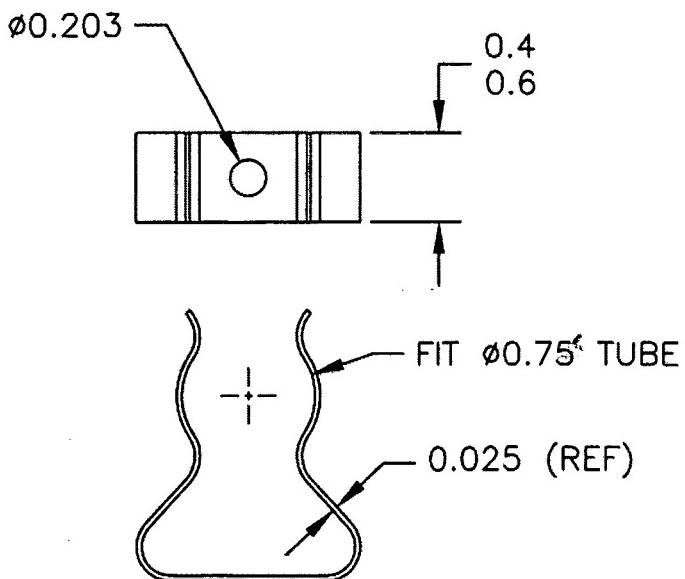
DESCRIPTION: STEEL CLIP, $\phi 0.75$

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

CAN MAKE FROM CRAWFORD PEG HOOKS, P/N #18612 (VENDOR: CANADIAN TIRE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

ALL DIMENSIONS ARE IN INCHES.

D3082-1 CLIP**RELEASED**
02.01.25 #

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 47840

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McMASTER-CARR®

200 Aurora Industrial Parkway
Aurora OH 44202
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Main Finished Goods Location

Purchase Order
PO00008787

Page 1 of 1

McMaster-Carr Number
6131848-01

05/13/2009

Line	Description	Ordered	Shipped
1	1722A43 Steel Tool Holder, Nickel-Plated, 5/8" to 1-1/4" Tool Diameter, 1-7/8" Projection, Packs of 10 Your Part Number: SELL IN STANDARD PACKS OF 10 EA	2 Packs	2
2	89315A41 Tin-Coated High-Speed-Steel Multi-Diameter Step Drill Bit, 13 Szs, 1/8"- 1/2", 1/32" Increments, 1/4" Shank Diameter	4 Each	4
3	93060A043 Economy Helical Insert Installation Tool, 3/8"-24 Internal Thread, Prewinder Style	1 Each	1

A11	1 - 692 - 02	03 - 86	A43	2PK	1

Certificate of compliance

This is to certify that the above items were supplied in accordance with the description and as illustrated in the catalog.

Jason Wolfe
Compliance Manager

Dart Aerospace Ltd

Assembly
Area

11

EXP

Cycle

16

Shelf

117

2 lbs
3 lines

Documents

3

FW1WBP13
05/13/2009
08:16/08:47
939



DART

Purchase Order

Date May 12, 2009	Page 1
Purchase Order Number PO00008787	

FAXED
15/05/13

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

Vendor Address:

McMaster-Carr Supply Co,
P.O. Box 7690
Chicago, IL 60680-7690
USA
Phone (330) 995-5500
Fax (330) 995-9600

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VU-MCM001	May 12, 2009	N30	Purolator	May 15, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
12.0000	1722A43	clip Comments: AS PER DWG D3082 REV. A B47846 MCMMASTER P/N: 1722A43	15/05/2009	No	1.800000	Each	21.60
4.0000	89315A41	1/8"-1/2" STEP DRILL	15/05/2009	No	21.790000		87.16
1.0000	93060A043	3/8"-24 INSERT TOOL	15/05/2009	No	31.280000		31.28

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Comments:	Tax Summary:	Less: included tax	0.00
		Subtotal	140.04
		Total tax	0.00
		Total purchase order in	
		USD Dollars	140.04

Entered By: CLAVOIE

Approved By: